

Work Order ID 70528

Friday, June 10, 2011 11:43:03 AM



Page 1

Item ID: D3454-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 6/10/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 6-10-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3454	Rev B								

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA573 & DWG D3454, □FOLIO
REV: N/A □DWG REV: *Handwritten signature* □2-DEBURR AS REQUIRED

Handwritten signature 11/6/14

30 *Handwritten signature*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Handwritten signature 11/6/14

30 *Handwritten signature*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Handwritten signature 11.6.14

30 *Handwritten signature*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 6/15/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00				30	0		
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.			116/14					
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00		11/15					
150 Packaging	Identify as per dwg & Stock Location: 54	0.00							
Packaging	Memo	0.00				11/6/15 SP	30		

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Stop



Item Name: Bushing

Start Date: 6/10/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15 *[Signature]*
ME
11-06-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 11:43:10 AM

Page 1

Work Order ID: 70528

Parent Item: D3454-7

Parent Item Name: Bushing



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV. A 05.11.17 New Issue EC
IPP Rev:B 08-04-25 chg to revB DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R0.750

Purchased

No

100

f

135.0000

0.0526

1.661053



303 Round Bar 0.750



11/6/14

Location

Loc Qty

Loc Code

MAT028

135

117328

39

117798

96

1.4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Dart Aerospace Ltd

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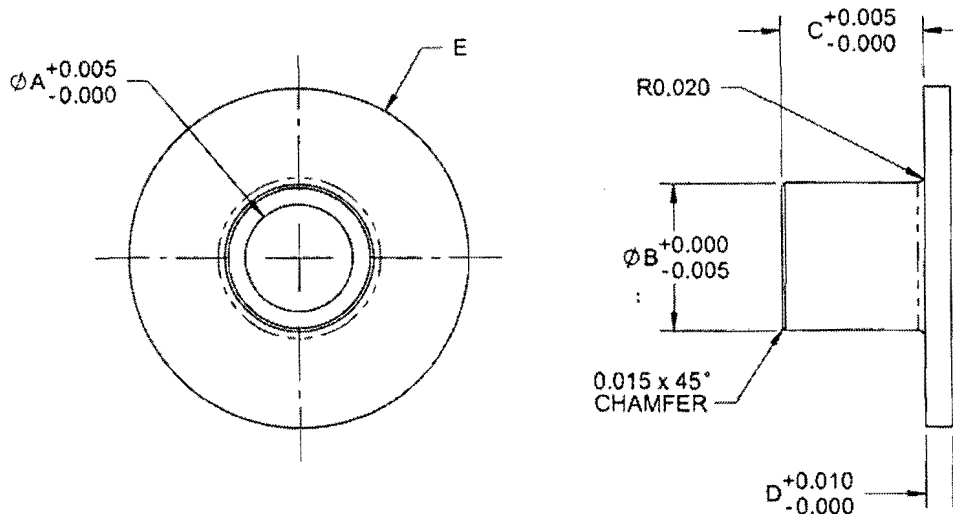
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3454	REV. B SHEET 1 OF 1
DATE 05.12.05	TITLE BUSHING SCALE 2:1		
A	05.09.02	NEW ISSUE	
B	05.12.05	REVISE -5/-7	

RELEASED

05.12.05 *[Signature]*



D3454-X

1) SPECIFICATION: D3454-X BUSHING

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
-7	0.250	0.372	0.343	0.060	0.75



NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70528

pl 11-06-10

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